

Work Order ID 72834

Tuesday, August 16, 2011 9:15:12 AM



Page 1

Item ID: D206-628-033

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step LH

Stop



Start Date: 8/16/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 8-18-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-033 CHG 003

Handwritten signature

8/16/11

for MF 11-9-19

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

8/16/11

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/16/11

8/16/11

VA

(x4 LH)

72836

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72834

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Page 2

Item ID: D206-628-033

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step LH

Start Date: 8/16/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-033 Location: <u> D </u> PPP Rev: <u> D </u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Handwritten signature and date: 8/16/11

Handwritten date: 11/9/20 and signature

Handwritten initials MF and date 11-09-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, August 16, 2011 9:15:18 AM

Page 1

Work Order ID: 72834

Parent Item: D206-628-033

Parent Item Name: Heli-Access-Step LH



Start Date: 8/16/2011

Required Date: 8/26/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM
IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C4A		Purchased	No			110	Each	1,361.000	3	12			
--------	--	-----------	----	--	--	-----	------	-----------	---	----	--	--	--



BOLT

Location

Loc Qty

Loc Code

ST350

1361

117313

2

117688

36

117795

1

117872

22

118012

260

118112

40

118451

1000

AN4C14A

Purchased

No

110

Each

52.0000

8

32



Bolt

Location

Loc Qty

Loc Code

ST337

2

117688

2

ST357

50

118267

50

AN4C15A

Purchased

No

110

Each

83.0000

4

16



Bolt

Location

Loc Qty

Loc Code

ST358

83

115835

2

117441

31

117795

50

4

118451

118706

118267

117795

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Tuesday, August 16, 2011 9:15:18 AM

Page 2

Work Order ID: 72834

Parent Item: D206-628-033

Parent Item Name: Heli-Access-Step LH

Start Date: 8/16/2011

Required Date: 8/26/2011

Start Qty: 4.00

Required Qty: 4.00

AN960C416L *NA611430432R*

Purchased No

110 Each

0.0000

24

96

WASHER

D2731-3

Manufactured No

110 Each

60.0000

4

16

Mounting Lug

Location

Loc Qty

Loc Code

ST469

60

47967

37

52329

23

D2732

Manufactured No

110 Each

606.3981

2

8

Rubber Extrusion

Location

Loc Qty

Loc Code

ST410

606.39811

64283

107.52811

70987

498.87

D2842-041

Manufactured No

110 Each

0.0000

1

4

Step Assembly, 206 Float

D2844-1

Manufactured No

110 Each

13.0000

2

8

Arm

Location

Loc Qty

Loc Code

ST263

10

70541

10

ST265

3

62954

3

Tuesday, August 16, 2011 9:15:19 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Tuesday, August 16, 2011 9:15:19 AM

Page 3

Work Order ID: 72834

Parent Item: D206-628-033

Parent Item Name: Heli-Access-Step LH

Start Date: 8/16/2011

Required Date: 8/26/2011

Start Qty: 4.00

Required Qty: 4.00

D2844-3 Manufactured No

110 Each

12.0000

1

4



Arm

Location

Loc Qty

Loc Code

ST266

12

66822

12

D3394-041

Manufactured No

110 Each

26.0000

4

16



Lug Assembly

Location

Loc Qty

Loc Code

ST

3

ST474

26

68257

26

MS21043-4

Purchased No

110 Each

969.0000

12

48



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

929

117793

482

118378

447

MS1149C0363R

Purchased No

110 Each

4,217.000

3

12



Washer

Location

Loc Qty

Loc Code

ST297

4217

114742

4217

Tuesday, August 16, 2011 9:15:19 AM

Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Tuesday, August 16, 2011 9:15:19 AM

Page 4

Work Order ID: 72834

Parent Item: D206-628-033

Parent Item Name: Heli-Access-Step LH

Start Date: 8/16/2011

Required Date: 8/26/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1515H3

Purchased

No

110

Each

250.0000

3

12



Washer

Location

Loc Qty

Loc Code

ST277

250

116373

6

117460

58

118078

6

118384

180

117960

NAS1515H4L

Purchased

No

110

Each

76.0000

24

96



WASHER

Location

Loc Qty

Loc Code

FG

36

103691

36

ST277

40

117363

40

1118709

8/16/11 (4)

Tuesday, August 16, 2011 9:15:19 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.2 D206-628-013/-014/-023/-024/-033/-034 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
1						D2841-041	FLOAT STEP ASSEMBLY LH
	1					D2841-042	FLOAT STEP ASSEMBLY RH
		1		1		D2842-041	FLOAT STEP ASSEMBLY LH
			1		1	D2842-042	FLOAT STEP ASSEMBLY RH
		2	2	2	2	D2844-1	ARM
		1	1	1	1	D2844-3	ARM
2	2					D2845	ARM
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*LUG
4	4			8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*LUG
8	8	8	8			*MS35489-93	*GROMMET
1	1					D4064-041	MOUNTING LUG
1	1					*D4064-1	*LUG
2	2					*MS35489-93	*GROMMET
2	2	3	3	3	3	AN3C4A	BOLT
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
4	4	8	8	4	4	AN4C15A	BOLT
2	2	3	3	3	3	NAS1149C0363R	WASHER (OR AN960C10)
16	16					NAS1149C0463R	WASHER (OR AN960C416)
8	8	24	24	24	24	NAS1149C0432R	WASHER (OR AN960C416L)
24	24	24	24	24	24	NAS1515H4L	WASHER
12	12	12	12	12	12	MS21043-4	NUT
2	2	3	3	3	3	NAS1515H3	WASHER

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE



5.3 QUICK RELEASE PIP PIN KIT

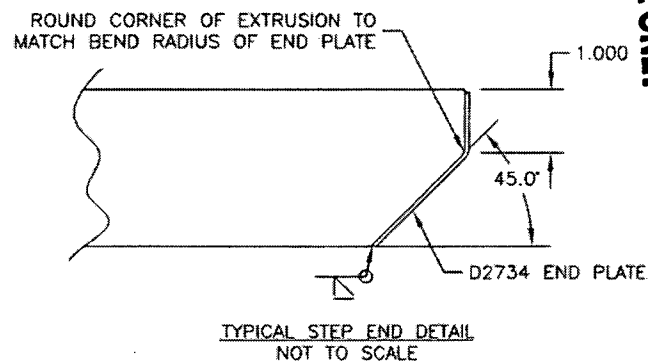
Qty -011	Part Number	Description
X	DSI9235-011	QUICK RELEASE PIP PIN KIT
4	BLRS-020	QUICK RELEASE PIN

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Revision: G

Date: 11.02.25

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. B
CHECKED 	APPROVED 	DRAWING NO. D2842	SHEET 1 OF 1	
DATE 05.09.23		TITLE 206L/407 FLOAT STEP ASSEMBLY	SCALE NPS	
A	98.10.13	NEW ISSUE		
B	05.09.23	RE-DESIGN, ADD D3459-1/-3		



D2842-041/-042 FLOAT STEP ASSEMBLY

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-11B	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REFERENCE ONLY

RELEASED
8-11-14

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